

Date: Monday, 10/22/2007 10:34:19 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE
Job Number	35257			
Estimate Number	12729			
P.O. Number	N/A		Part Number	D353539
This Issue	10/22/2007	S.O. No.	Drawing Number	D3535 REV B
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	B'
Previous Run	33629		Material	N/A
Written By			Due Date	10/31/2007
Checked & Approved By	<u>HB 07-10-22</u>		Qty:	<u>26</u>
Comment	Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet  <u>25.9636</u>
		Comment: Qty.: 0.9986 sf(s)/Unit Total : 15.9768 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: <u>105871</u> <u>HB 07-10-23</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> <u>HB 07-10-23</u> Prog Rev: <u>B</u>
		2-Deburr if necessary <u>HB 07-10-23</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <u>HB 07-10-23</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  <u>8 07-10-08</u> <u>HB 07-10-23</u> <u>26</u> <u>coaster</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. Identify as D3535-41 Form Joggle on brake using Jig DT8158 as per Dwg D3535
		<u>SB 07-10-31</u> <u>26</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ID Date: 07/11/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 10:34:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35257

Part Number: D353539

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/10/31 426

ocentos

7.0 POWDER COATING

POWDER COATING



M105642



(26)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BL 07-01-02

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(26)

Comment: INSPECT POWDER COAT

BL 07-11-02

9.0 PACKAGING 1

PACKAGING RESOURCE #1



(26)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

BL 07-11-02

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(26)

Comment: FINAL INSPECTION/W/O RELEASE

2011105

Job Completion



C 07/11/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35257
Description: Wearshoe	Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1

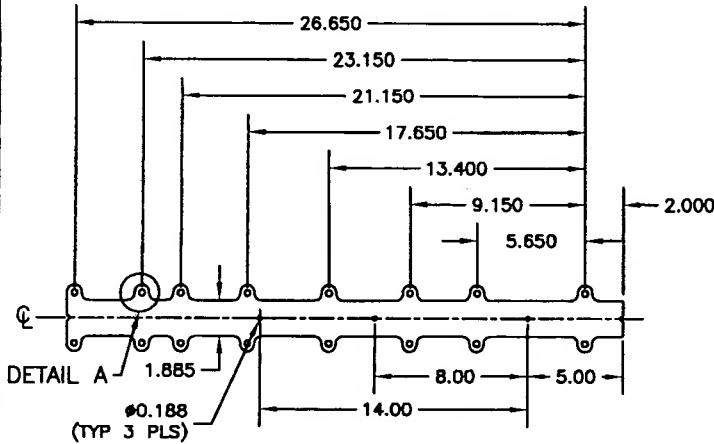
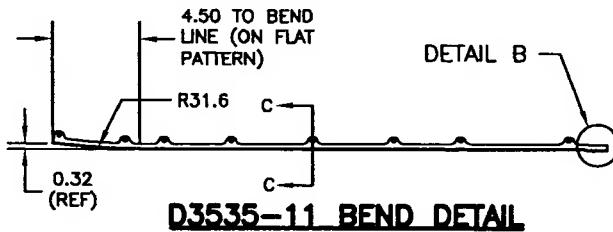
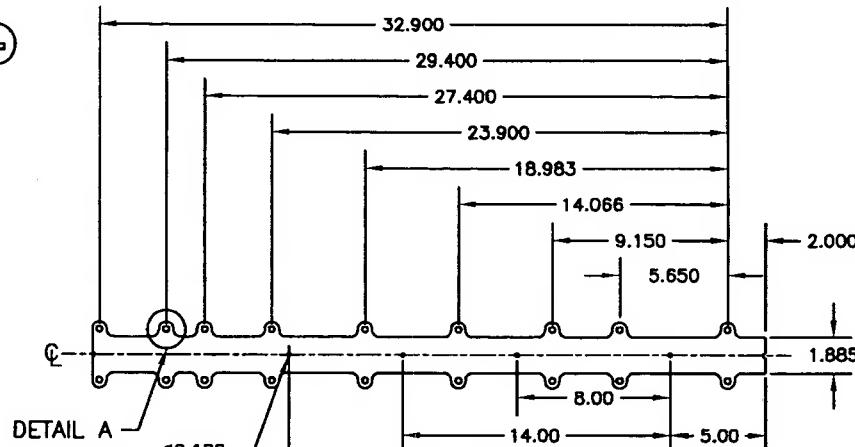
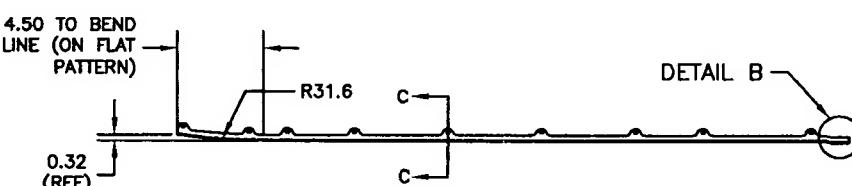
### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	X			
32.775	+/-0.010	32.775				
29.275	+/-0.010	29.275				
25.775	+/-0.010	25.775				
23.250	+/-0.010	23.250				
19.750	+/-0.010	19.750				
17.750	+/-0.010	17.750				
14.250	+/-0.010	14.250				
9.500	+/-0.010	9.500				
4.750	+/-0.010	4.750				
2.000	+/-0.010	2.000				
5.00	+/-0.030	5.00				
9.00	+/-0.030	9.05				
28.00	+/-0.030	28.00				
Ø0.188	+0.005/-0.001	.189				
1.885	+/-0.010	1.885				
0.300	+/-0.010	.302				
0.300	+/-0.010	.304				
0.038	+/-0.010	.034				

Measured by:	B	Audited by:	E	Prototype Approval:	N/A
Date:	07-10-23	Date:	07/10/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	E

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

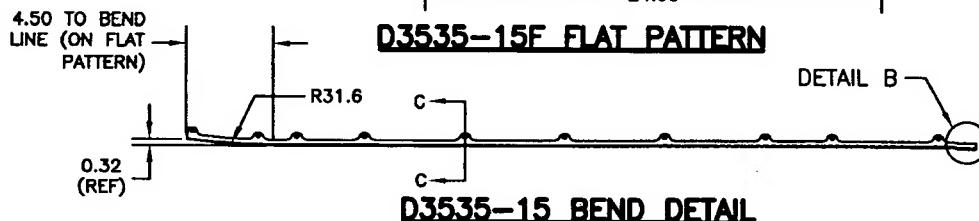
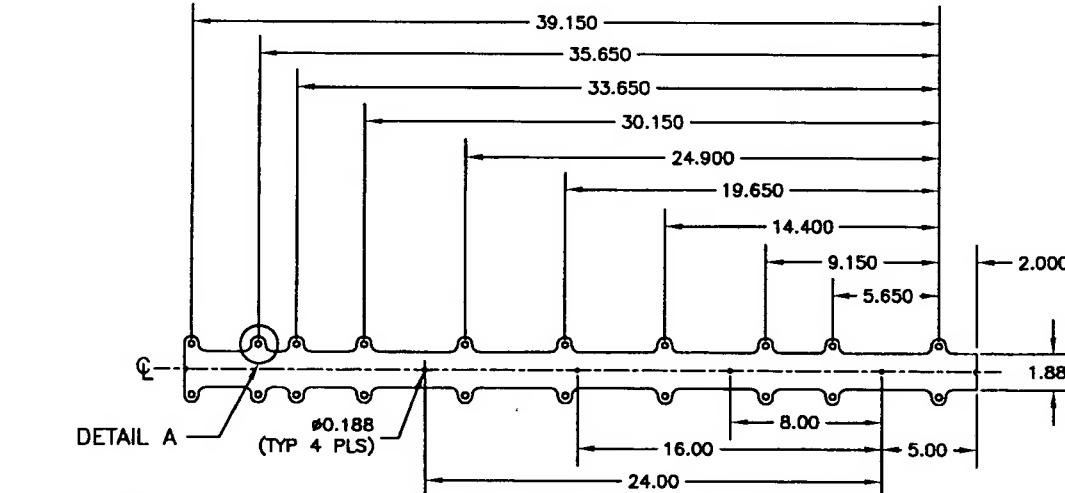
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CHECKED <b>TH</b>	APPROVED <b>TH</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>
A <b>06.10.25</b>		NEW ISSUE
B <b>07.04.17</b>		MOVE TAB OUTBOARD, ADD AMS SPEC

REV. B  
SHEET 1 OF 7  
SCALE  
1:10

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 2525

NOTES

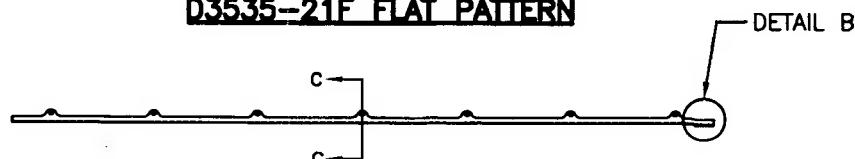
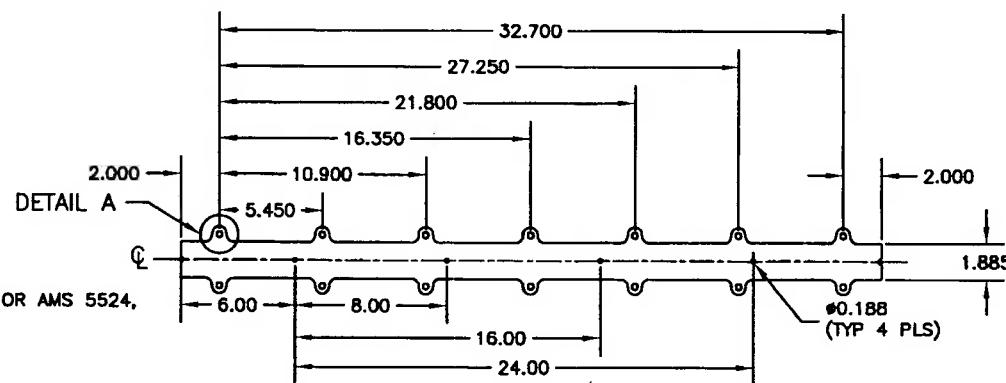
- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

**DART**RELEASED  
07.04.17

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No 3535

**NOTES**

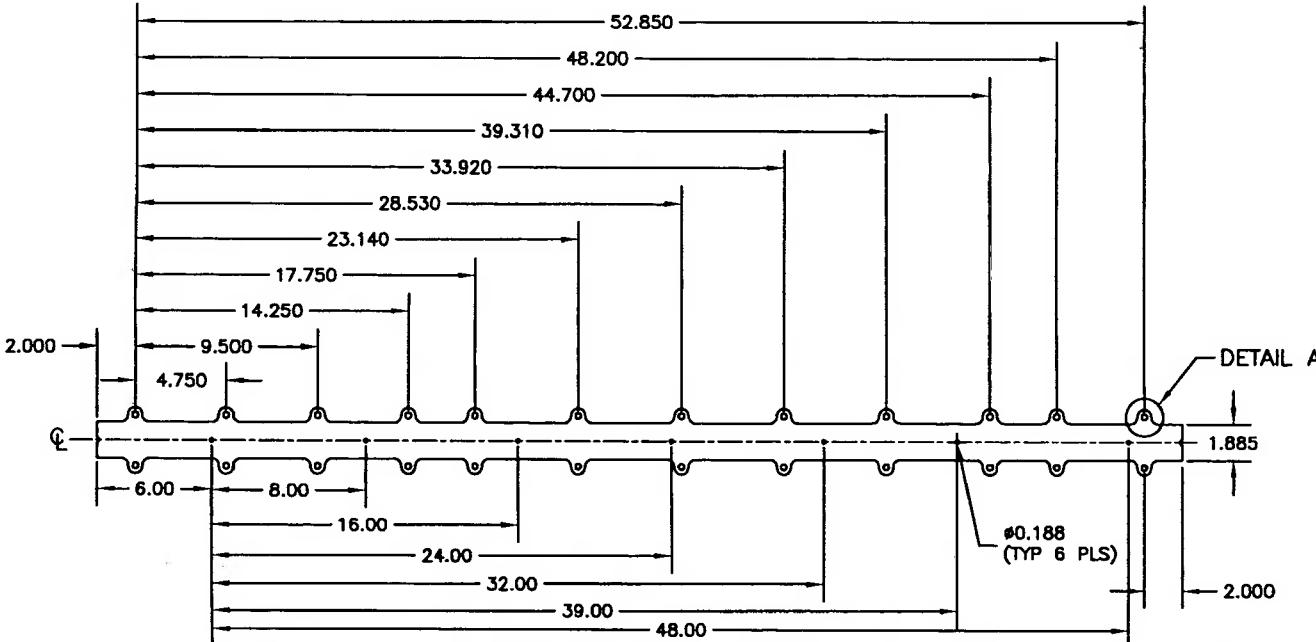
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



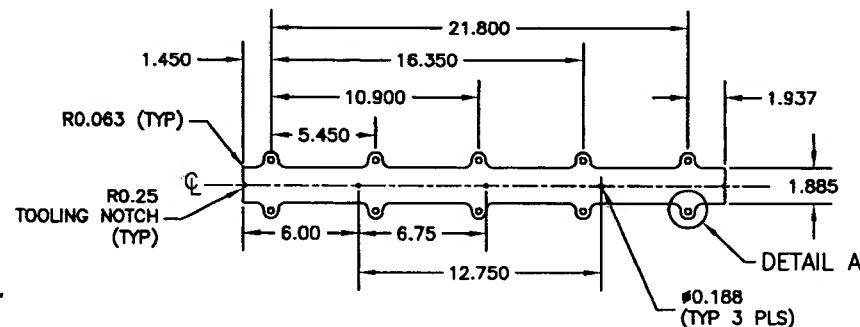
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CHECKED	APPROVED	P.O.R.T HADLOCK, WA
DATE		DRAWING NO.
		D3535
		TITLE
		WEARSHOE
07.04.17		SCALE
		1:10
		REV. B
		SHEET 2 OF 7

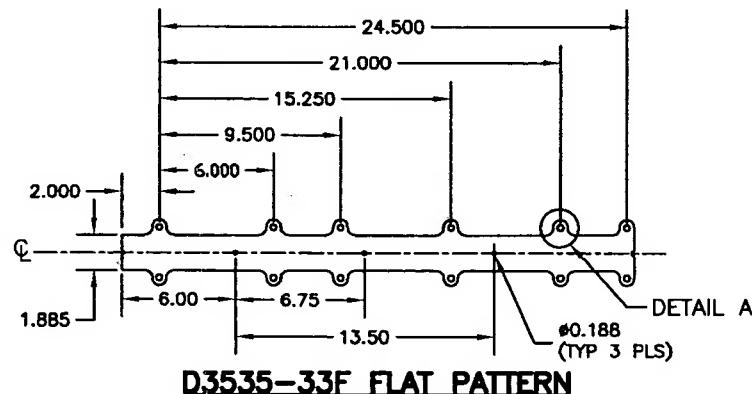
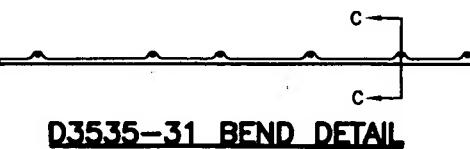
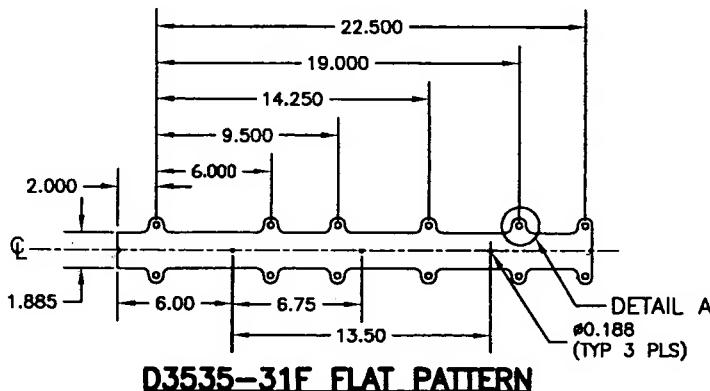
**DART**

DESIGN C.B	DRAWN BY <i>PW</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10

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07.04.24  
*M***D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL**

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**D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL**

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07.04.17

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WITHOUT NOTICE  
WORK ORDER  
NO. 3525

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

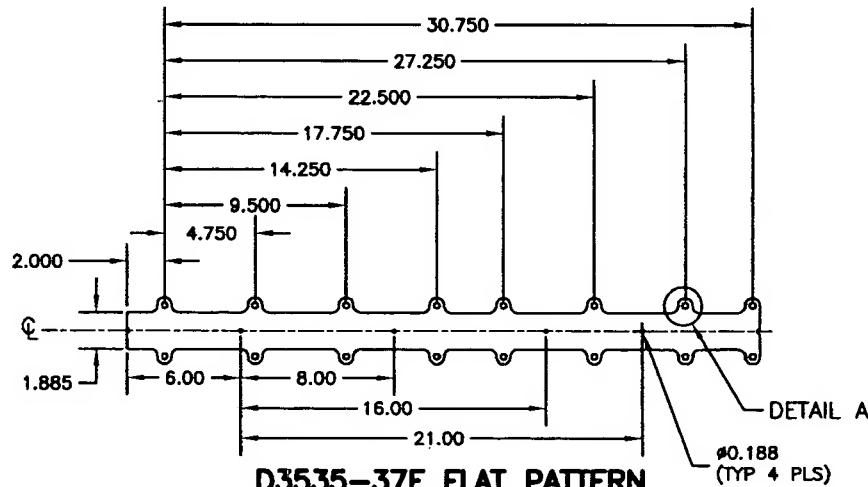
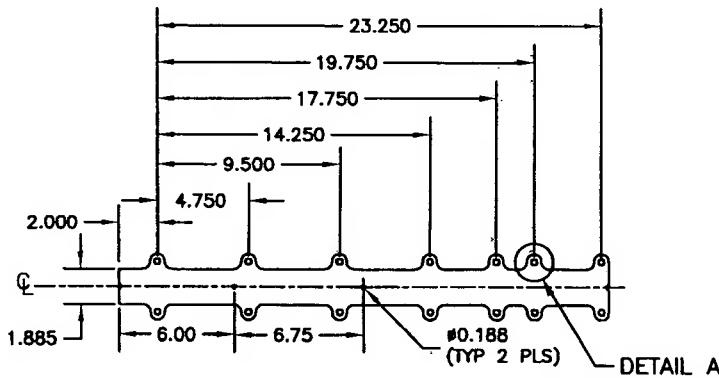
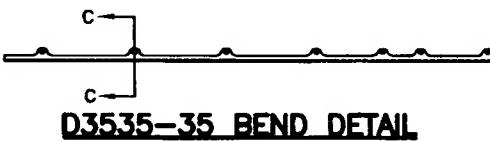
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
<b>CB</b>	<b>PH</b>	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[initials]</i>	<i>[initials]</i>	D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B		SHEET 4 OF 7
SCALE		1:10

**DART**

RELEASED

07.04.17

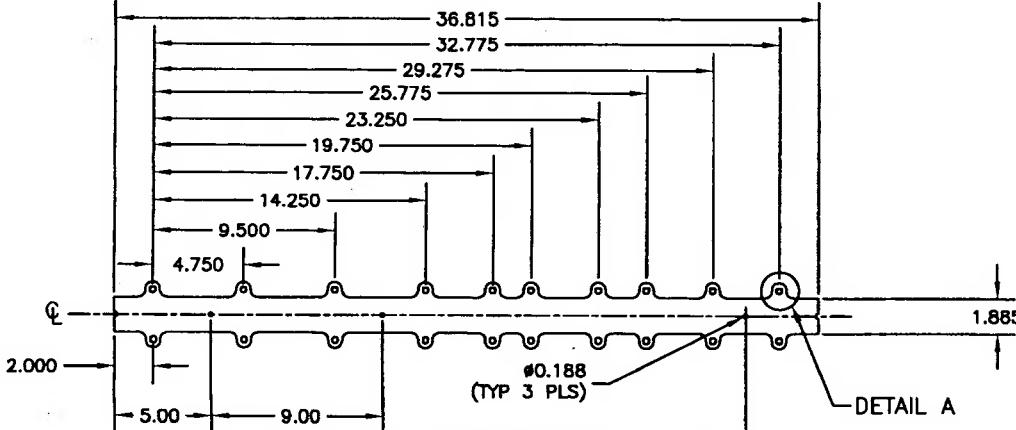
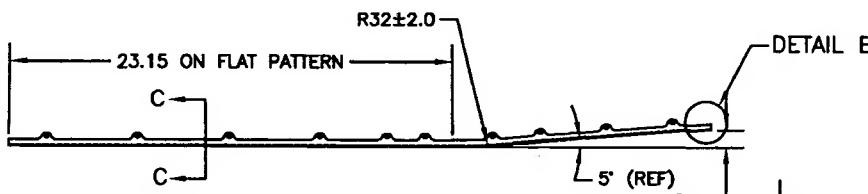
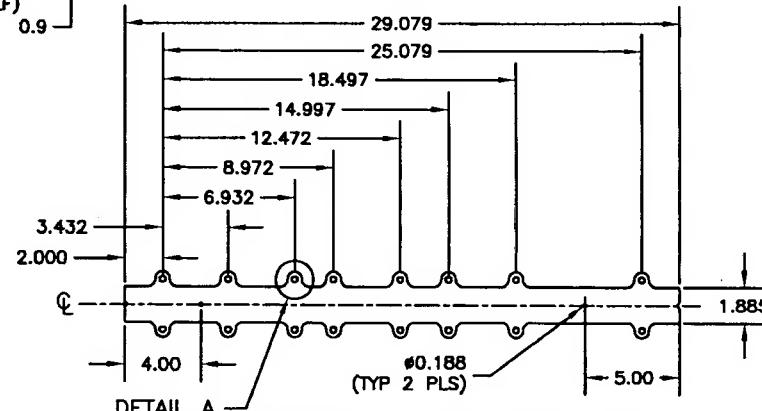
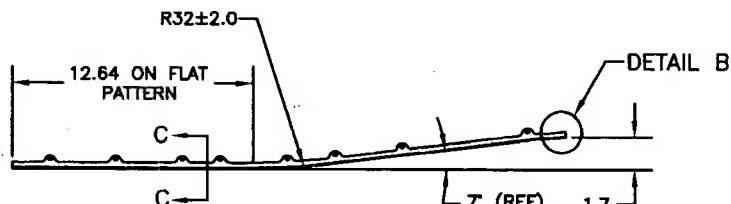
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CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7 SCALE 1:10

**D3535-37 BEND DETAIL****D3535-35 F FLAT PATTERN****D3535-35 BEND DETAIL**

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**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**RELEASED  
07.04.24**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	RH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B		SHEET 6 OF 7
SCALE		1:10

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WITHOUT NOTICE  
WORK ORDER  
NO. 3535

**NOTES**

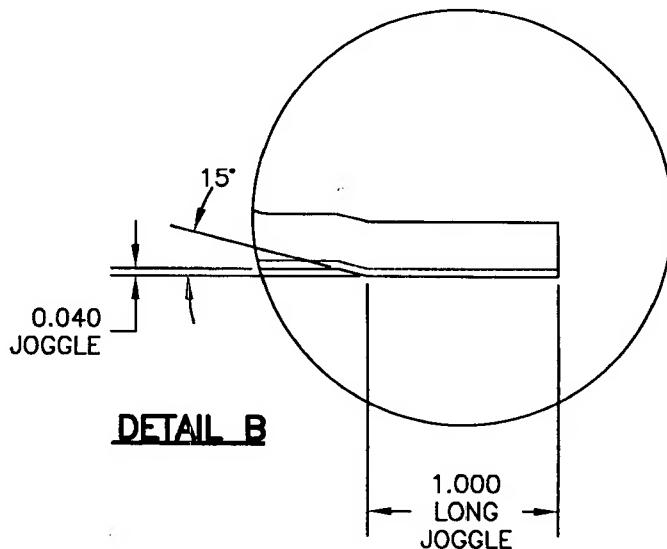
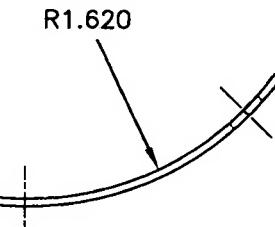
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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

DESIGN <b>C8</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 7 OF 7 SCALE 1:1

RELEASED  
*[Signature]*

07.04.24

**DETAIL B****SECTION C-C**

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WORK ORDER  
NO. **35257**

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